

**Abstract of the Disclosure**

A method of detachably mounting a rotating tool provided with an attachment portion having a cylindrical inner circumferential surface (or outer circumferential surface) to a mounting portion having a cylindrical outer circumferential surface (or inner circumferential surface) of a spindle. The inner diameter (or outer diameter) at normal temperatures of the attachment portion is made larger (or smaller) than the outer diameter (or inner diameter) at normal temperatures of the mounting portion. The attachment portion is heated (or cooled) and/or the mounting portion is cooled (or heated) to make the inner diameter (or outer diameter) of the attachment portion larger (or smaller) than the outer diameter (or inner diameter) of the mounting portion to fit the mounting portion onto (or into) the attachment portion.